

Work Order ID 72377

Monday, July 25, 2011 10:02:11 AM



Page 1

Item ID: D350-721-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

7-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-721-041CHG004

MLJ 12/05/10

(1)

12-05-10

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

12/05/10

1X SP12-5-9

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg IIN-D350-721 Attach Travelers:

2-Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex

Batch: *D1221*

Exp Date: *12-1*

1/0

SP1259

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72377

Monday, July 25, 2011 9:13:57 AM

Page 2

Item ID: D350-721-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140  Packaging Packaging	Pick Kit Memo	0.00 0.00							
150  QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

8/10/10

1x

SD
12-5-10

①

WHL
12-05-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop

Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-721-041

Location:

PPP Rev: E

IX

SP
12-510

170

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

MWS 12/05/10

MWF
12-0510

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, July 25, 2011 9:14:03 AM

Page 1

Work Order ID: 72377

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D as per Rev B 05-11-21 JLM
IPP Rev:E 08-05-14 now @ chg 003 as per ECN1187 DD verified
by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A



Bolt

Purchased

No

Each

295.0000

8

m120422 STE

Location

Loc Qty

Loc Code

ST357

195

117423

195

ST358

100

118112

100

AN4-20A



Bolt

Purchased

No

110

Each

576.0000

1

m121060 SP

Location

Loc Qty

Loc Code

ST359

576

115936

76

116419

200

117514

300

AN4-22A



Bolt

Purchased

No

110

Each

154.0000

1

m118628 SP

Location

Loc Qty

Loc Code

ST359

154

114784

6

116419

49

117313

99

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-7A



Bolt

Purchased

No

110

Each

222.0000

2

2



SP

Location

Loc Qty

Loc Code

ST356

222

117443

22

117514

200

110

Each

108.0000

4

4



2X
M121181 SP

AN5-17A



Bolt

Purchased

No

Location

Loc Qty

Loc Code

ST337

50

118422

50

ST339

58

117619

14

117872

44

110

Each

0.0000

2

2



M121255 SP

AN960JD416



Washer

AN960JD416L



Washer

NAS1149D0463J

Purchased

No

NAS1149D0416J

Purchased

No

110

Each

19.0000

2

2



M120833 SP

Location

Loc Qty

Loc Code

FP-B

17

110153

17

ST298

2

110153

2

110

Each

0.0000

4

4



M119546 SP
12-5-9

AN960JD516



Washer

NAS1149D0563J

Purchased

No

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Monday, July 25, 2011 9:14:04 AM

Work Order ID: 72377

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN9601D8

NAS1149DN832J Purchased

No

110

Each

0.0000

2

2

Washer

AN9601D9

Purchased

No

110

Each

0.0000

32

32

Washer

AN970-4

Purchased

No

110

Each

305.0000

4

4

Washer

Location

Loc Qty

Loc Code

ST342

293

117795

293

ST344

11

115936

11

ST349

1

116900

1

D2022-101

Manufactured

No

110

Each

62.0000

2

2

Spacer

Location

Loc Qty

Loc Code

ST504

62

69532

2

69824

60

D2332-041

Manufactured

No

110

Each

4.0000

1

1

Lid Prop Assembly 6.69" long

Location

Loc Qty

Loc Code

ST512

4

70997

4

m/204228p

32 4k m/20833
28x m/17868 sp

m/21285 sp.

B770 478p

B71353 sp
12-5-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2530
Handle Weldment

Manufactured No 110 Each 12.0000 1



1
B82895 SP.

Location Loc Qty Loc Code

ST506 11

70850 11

ST508 1

69318 1

D2535
Spring

Manufactured No 110 Each 105.0000 2



2
B83545 SP.
~~B82896 SP.~~

Location Loc Qty Loc Code

ST504 105

69495 5

71117 100

D2537
Bushing

Manufactured No 110 Each 10.0000 2



2
B82896 SP.
~~B82896 SP.~~
~~B83545 SP.~~

Location Loc Qty Loc Code

ST504 10

69894 10

D2931
Bumper

Manufactured No 110 Each 616.0000 2



2
SP 12-5-8

Location Loc Qty Loc Code

ST504 616

46064 616

2x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D3320-041

Manufactured No

110

Each

10.0000

1

1



Webbing



SP

Location

Loc Qty

Loc Code

ST483

10

52376

10

D3324-041

Manufactured No

110

Each

0.0000

1

1



Basket Base Assembly

D3325-041

Manufactured No

110

Each

0.0000

1

1



Basket Lid Assembly

D3351-1

Manufactured No

110

Each

22.0000

1

1



Placard



SP

Location

Loc Qty

Loc Code

ST048

22

46116
61577

6

16

MS20600-AD4W2

Purchased

No

110

Each

288.0000

2

2



Rivet



M120142 SP

Location

Loc Qty

Loc Code

ST321

288

116391

5

116471

4

116805

4

117601

1

117885

174

118354

100

12-5-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600:AD4W3

Purchased

No

110

Each

847.0000

32

32



Cherry Rivets



m118626 sp

Location

Loc Qty

Loc Code

ST321

714

111636

112

117505

452

117601

150

WA018

133

107939

133

MS21042L3

Purchased

No

110

Each

1,422.000

2

2



Nut



m121349 sp

Location

Loc Qty

Loc Code

ST300

1414

117441

654

117601

400

117885

360

MS21042L4

Purchased

No

110

Each

3,565.000

4

4



Nut



m121011 sp
1258

Location

Loc Qty

Loc Code

ST300

3553

117441

1402

117601

651

117885

1500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 72377

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A
Bolt

Purchased No

~~140~~
110 Each

93.0000

2 2

m/20986 SP

Location

Loc Qty

Loc Code

ST352

93

117441

93

140

Each

140.0000

2 2

m/204238 SP

AN4-12A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST357

140

112314

2

115422

38

117508

100

140

Each

143.0000

4 4

m/21243 SP

AN4-14A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST357

143

117872

143

140

Each

0.0000

28 28

m/21255 SP
125-9.

AN960JD416

NAS1149D0463J

Purchased No

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2230-1

Manufactured No

140

Each

251.0000

Lug

Location

Loc Qty

Loc Code

ST476

251

67826

6

69179

45

69821

100

70974

100

D2230-3

Manufactured No

140

Each

194.0000

Lug

Location

Loc Qty

Loc Code

ST

70

70694

70

ST476

4

53881

4

ST480

120

70973

120

D2732-030

Manufactured No

140

Each

6.0000

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

6

69205

6

D3338-1

Manufactured No

140

Each

8.0000

Mounting Lug

Location

Loc Qty

Loc Code

MEZZ

8

48426

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D3350-041

Manufactured No

140

Each

2.0000

2

2

Strut Assembly

Location

Loc Qty

Loc Code

ST271

2

52276

2

Purchased

No

140

Each

3,565.000

18

18

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

3553

117441

1402

117601

651

117885

1500

Purchased

No

140

Each

1,304.000

4

4

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1304

116105

5

116548

115

117441

498

117591

100

117611

90

118179

496

m121011 sp

125-8

Monday, July 25, 2011 9:14:05 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

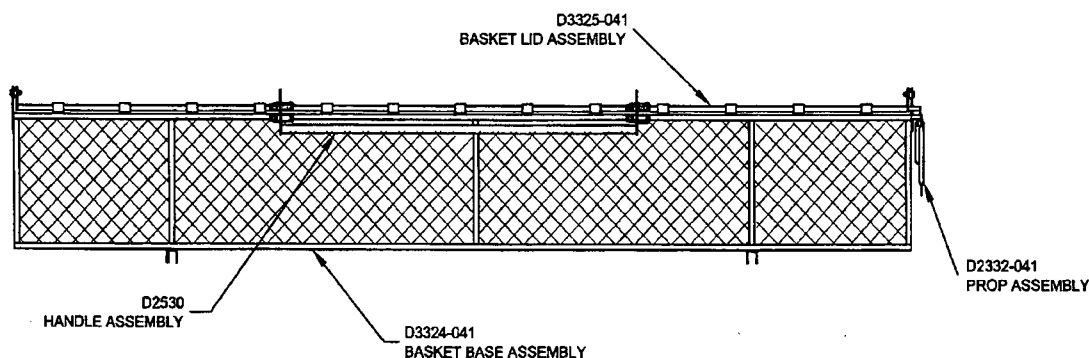
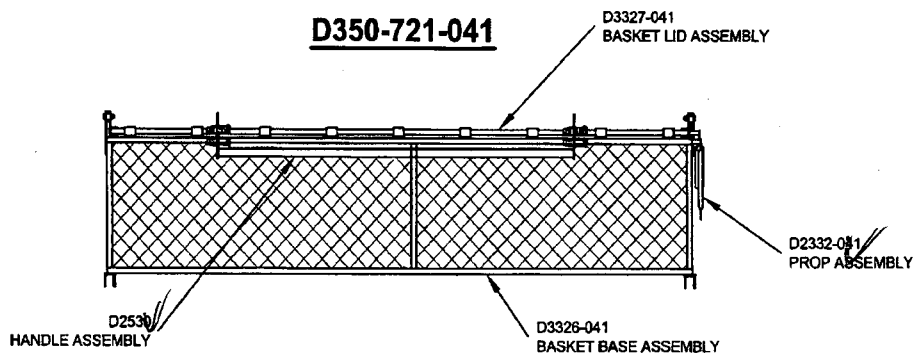
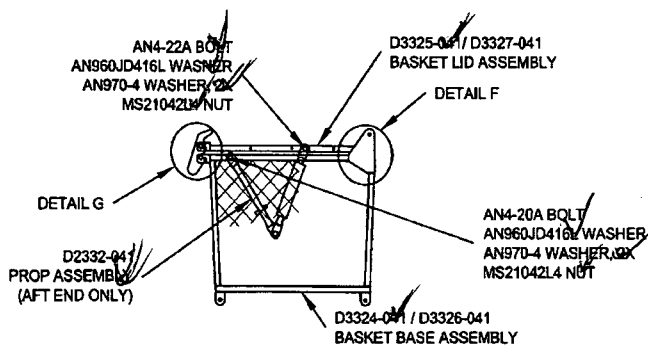
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6.0 PARTS LIST

Qty -011	Qty -041	Qty -043	Qty -045	Qty -046	PART NUMBER	DESCRIPTION
X					D350-721-011	BASKET CLAMP KIT
	X				D350-721-041	LIGHTWEIGHT HELI- UTILITY-BASKET™
		X			D350-721-043	LIGHTWEIGHT HELI-UTILITY-BASKET™, SHORT VERSION
			X		D350-721-045	MAINTENANCE STEP, LH
				X	D350-721-046	MAINTENANCE STEP, RH
	1	1	1	1	D3324-041	BASKET BASE ASSEMBLY
	1	1	1	1	D3325-041	BASKET LID ASSEMBLY
		1			D3326-041	BASKET BASE ASSEMBLY
		1			D3327-041	BASKET LID ASSEMBLY
	2	2	2	2	D2022-101	SPACER
3	3	3			D2230-1	LUG
4	4	4			D2230-3	CLAMP
	1	1	1	1	D2332-041	PROP ASSEMBLY
	1	1	1	1	D2530	HANDLE ASSEMBLY
	2	2	2	2	D2535	SPRING
	2	2	2	2	D2537	BUSHING
8	8	8			D2732-030	RUBBER CUSHION
	2	2	2	2	D2931	BUMPER
	1	1	1	1	D3338-1	LUG
	2	2	2	2	D3350-041	STRUT
	1	1	1	1	D3351-1	LABEL
			1	1	D3436-041	CLAMP
			1		D3436-043	LH STEP
				1	D3436-044	RH STEP
	2	2	2	2	AN3-16A	BOLT
	2	2	2	2	AN4-7A	BOLT
	2	2	2	2	AN4-12A	BOLT
	4	4	4	4	AN4-14A	BOLT
8	8	8			AN4-15A	BOLT
			4	4	AN4-16A	BOLT
	1	1	1	1	AN4-20A	BOLT
	1	1	1	1	AN4-22A	BOLT
	4	4	4	4	AN5-17A	BOLT
			8	8	AN960-416	WASHER
16	30	30			AN960JD416	WASHER -2
	2	2	2	2	AN960JD416L	WASHER
	4	4	4	4	AN960JD516	WASHER
	2	2	2	2	AN960JD8	WASHER
	4	4	4	4	AN970-4	WASHER
			4	4	MS20365-428	NUT
	2	2	2	2	MS20600AD4W3	RIVET
	2	2	2	2	MS21042L3	NUT (OR MS21042-3)
8	18	18			MS21042L4	NUT (OR MS21042-4) -2-2
	4	4	4	4	MS21042L5	NUT (OR MS21042-5)

**D350-721-041****D350-721-043**

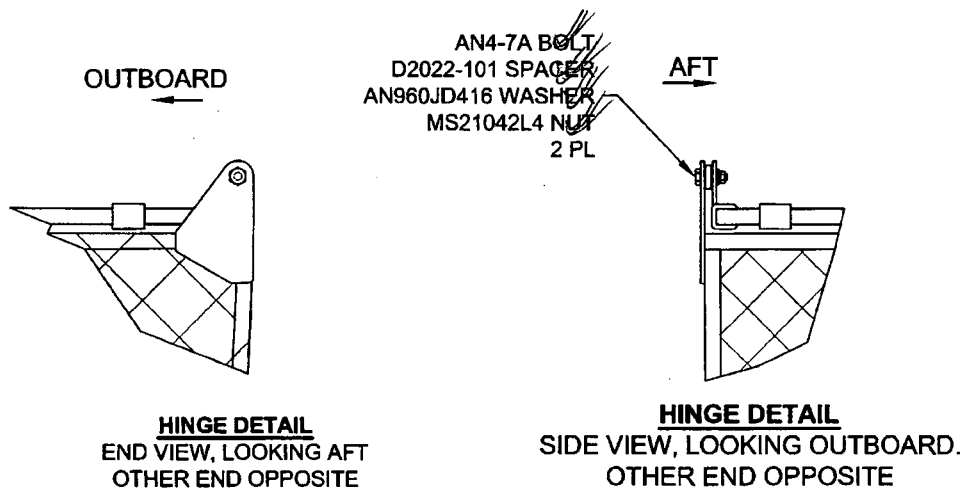
VIEW C-C:
PROP ARM DETAIL

Figure 3 – Basket Replacement Parts
(D350-721-041/-043 Lightweight Heli-Utility-Basket™)

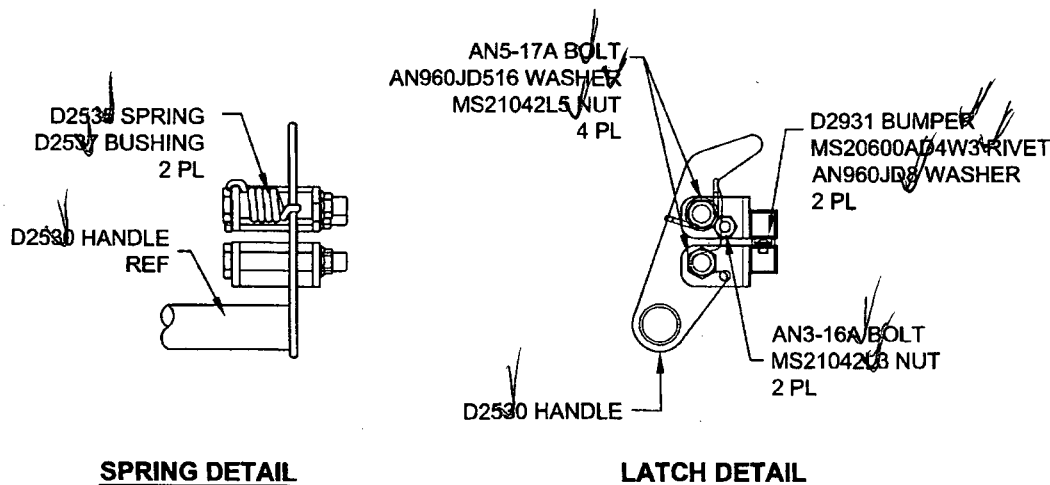
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Date: 10.06.15



DETAIL F:
HINGE



DETAIL G:
HANDLE WELDMENT

Figure 4- Basket Replacement Parts
(D350-721-041/-043 Lightweight Heli-Utility-Basket™)

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